Quality Control

DQA:		Date:	
------	--	-------	--

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: DISPOSITION AGAINST DEPARTMENT/PROCESS Work Order: Engineering Crosstube Water Jet Rework Skid-tube Machining Small Fab Prod. Eng. Coor. Quality Part No. Scrap Use-as-is Thermoforming Finishing Rec/Store/Packaging Other NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Initial Action Sign & Root Date Qty or Non-conformance Chief Eng Verification Cause Step Description Date QC Inspector Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bending Bend Grain Ovalized Pressure/Forced BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Weld Inspection Incomplete Part Incorrect Instructions Incomplete/Unclear Crushed/Crimped Burrs Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved **Heat Treat** Countersink Mislabeled **Positioned Wrong** Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend **Drill Holes** Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence **Finish** Out of Sequence Folio

Outside Dimensions

Wave/Twist in Tube

NCR:

Yes / No

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 96106 <i>January-23-13 8:46:47 AM</i>					Page 2						
Item ID: Revision ID: Item Name:	D2365 Wearplate			Accept	*N900	0401	ΛN	* S	etup Star Stoj	1 14	S1* S2*
Start Date: Required Date: Reference:	2/01/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:					. 12
Approvals:		an:	Date:			ate:		R	un Stai Sto	1/7	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID			Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* HandFinish Hand Finishing		Chemical Conversion Co Memo	at per QS1005 4.1	0.00			-	10	Z	B13	3.13
*140 *140* QC Quality Control		Q03 Inspect Part Finish Memo		0.00			-	lox			J3/03/
150 *150* Small Fab Small Fab		Small Fab Memo	as per Dwg D2365	0.00				10x			J3/03/1

c

												DQA:	Date:	
NCR:	⁄es	/ No					WORK ORDER NON-C	CON	NFORM	AANCE / UP	DATE			
-							· - · - · · · · · · · · · · · · · · · ·					QA Closed:	Date:	
Nork Orde	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part P	Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Small Fab	Water Jo Prod. Eng. Coo Rec/Store/Packagin Supplie		Engineering Quality Other
								'				_ .	'' -	
Root Cause		Date	Step	Qty	Des	•	ntion of work order update	i	nitial ief Eng		ion ription	Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup pther rocess upplier raining napproved														
							F.	AUL	T CATE	GORY				
Landi	ng (ear					General							
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ware ection Incomplete uctions Incomplete/Unclear ntenance abeled ead		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Turning Sequence						Finish		Out of	Sequence		-		

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Order ID 96106 January-23-13 8:46:47 AM				*961					Page 3			
Revision ID:	D2365 Wearplate			Accept	*N900	040	100)*	Setup	Start Stop	*N: *N	S1* S2*
Start Date: Required Date: Reference:	2/01/13 2/01/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:						
Approvals:	Process	Plan:	Date:	Tooling:	Da	ate:			Run	Start Stop	*N	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC5- Inspect part comple Memo		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qt. \2	y >-OS-		Insp. Stamp OAS O9 89
Packaging 180 *180* QC Quality Control	·	Memo QC21- Final Inspection - Memo	Work Order Release	0.00					17.	13	DOC M:	13-3-2° F 53-20

												DQA:	Date	:			
NCR:	Yes	/ No					WORK ORDER NON-C	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date				
							DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Vork Ord	er:		-				Davis at [,		cui a a de a	C	1	Water Jet	Engineering			
Dort	NI.a						Rework Scrap	1 1		Skid-tube Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	Quality			
Part	NO.			· ·····			Use-as-is	1	l	noforming	Finishing	4	re/Packaging	Other			
NCR No.							Work Order Update]		Large Fab	Composite	i ilee/stoi	Supplier				
Root					Des	crir	otion of work order update		nitial	Ac	tion	Sign &					
Cause		Date	Step	Qty			r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector			
oc/Data																	
uip/Tooling										:			,				
perator								1									
aterial																	
etup																	
ther	L											1					
ocess																	
upplier																	
raining																	
napproved							······································	<u>_</u>					<u> </u>				
								AUI	T CATE	GORY							
Land	ing	7					General 1		1			٦	Г				
	\vdash	Bending	_		- 1-	<u> </u>	Bend	<u> </u>	Grain		-	Ovalized	<u> </u>	Pressure/Forced			
	<u> </u>	Centre No	ot Conce	ntric to	O/S	_	BOM/Route	-	Hardwa			Over/Under	-	Temperature/Cure Weld			
	-	Cracks				L	Broken/Damaged	\vdash	4	ion Incomplete	(1) l	Part Incorre		 			
	\vdash	Crushed/	Crimped.			_	Burrs	\vdash	4	tions Incomplete/	Unclear	Part Lost/M	Issing	Wrong Stock Pulled			
	\vdash	Cuffs			,	\vdash	Contamination	-	4	enance	-	Part Moved	Mrong				
	\vdash	Heat Trea		. Tl		-	Countersink	-	Mislabe		-	Positioned \ Power Loss		Other			
	\vdash	Inspectio	•	ilube		\vdash	Cut Too Short Drill Holes	-	Misread Offset	u	L	Trower ross	Suige [Totilei			
├ ─┤ ``						Out of Calibration											
	\vdash	Turning S			11	\vdash	Drawing Finish	-	-1	Sequence							
	1	11011111112 2	eauence			ı	10111311	1	TOUL OI.	JEGUENCE							

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Picklist Print

January-23-13 8:46:46 AM

Work Order ID:

Parent Item:

D2365

Parent Item Name:

Wearplate

96106

124003

Start Date: 2/01/13 Start Qty: 10.00

Required Date: 2/01/13

Page 1

Required Qty: 10.00

Comments:

IPP Rev A

Removed from 9 Digit 05-12-05 JLM

Comments.		Now On Waterjet	_	-04-04 JLM	Verified By:	EC							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty		Date Issued	Status
FE-832-EF PEM Insert		Purchased	No	7902	33(5)	100 B960	38 US	9000	2	20	1/3	3/03	/14_
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No	9,55		150	sf	324.0625	0.0047	0.04947	<u> </u>	13.0	3 · 10_
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT021		,324.0625							
				123	135	124.4625			*****				

199.6

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
	•										QA C	losed:	Date:	
Work Orde	r:					DISPOSITION				AGAINST [EPART	MENT	_	
Part N	o					Rework Scrap		Skid-tube Crosstube Machining Small Fab					Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite		ec/Stor	e/Packaging Supplier	Other
Root				Desc	rip	tion of work order update		nitial	Act	tion	Sig	n &		
Cause	Da	e Ster	Qty		10	r Non-conformance	Ch	ief Eng	Desc	ription	D	ate	Verification	QC Inspector
oc/Data														
quip/Tooling													•	
perator														
/laterial													!	
etup														
Other														
rocess														
upplier			İ											
raining			ļ								ļ			
Inapproved											-			
						F	AUL	T CATE	GORY					
Landin	g Gear			-		General								
ſ	Bend	ng				Bend		Grain			Ovali	zed		Pressure/Forced
	Cent	e Not Cond	entric to	o/s		BOM/Route	Г	Hardwa	re		Over	/Under	tolerance	Temperature/Cure
Ī	Crack	s				Broken/Damaged		Inspect	ion Incomplete		Part	Incorre	ct	Weld
Ī	Crust	ed/Crimpe	ed.	Ī		Burrs		Instruct	ions Incomplete/	'Unclear	Part	Lost/M	issing	Wrong Stock Pulled
Ì	Cuffs					Contamination		Mainte	enance		Part	Moved	_	1
ľ	_	Treat		ļ	\neg	Countersink		Mislabe	eled		Posit	ioned \	Wrong	
Ī	Inspe	ction Strip	in Tube	Ţ	\exists	Cut Too Short		Misread	d	Ī	Powe	er Loss/	'Surge	Other
Ì	- '	es in Bend			\exists	Drill Holes		Offset		•	_		_	
	— 1 ``	ie Waves i	n Extrusio	on	ヿ	Drawing		Out of	Calibration					
Turning Sequence Finish					Out of Sequence									
	Wave/Twist in Tube				—₹	Folio		Outside	Dimensions					

DQA: ____ Date: ____

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

3, 4,

DART AEROSPACE LTD	Work Order:	96106
Description: Wear Plate	Part Number:	D2365
Inspection Dwg: D2365 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
---	---------------	-----------

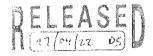
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.010	1.250	V		Ver	MM-01
1.000	+/-0.010	1.002	1		vern vern vern vern	
0.625	+/-0.010	0.625	/		Vehr	
0.250	+/-0.010	0.251	1		very	
0.500	+/-0.010	0.500	V		van	
R0.125	+/-0.010	RO.125	1		R.G	
Ø0.290	+0.006/-0.001	0.290	V		VerN	
Ø0.191	+0.005/-0.001	6.181	<i>\(\sqrt{\sq}}\sqrt{\sq}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}</i>		Vern	

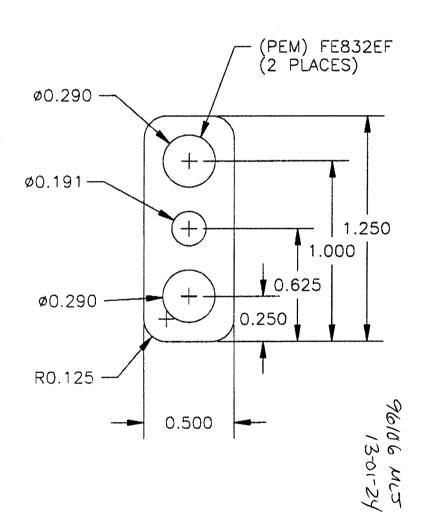
Measured by:	whit	Audited by:	21	Prototype Approval:	N/A
Date:	13.03.10	Date:	13310	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.06.25	New Issue P/O D350-616-015	KJ/JLM 1,0	
В	08.10.09	Dimensions revised	KJ/DD O	7



o∈ B	SIGN WILLIAMS	ORAWN BY B WILLIAMS	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,		
CH	IECKED		DRAWING NO.		REV. C
1	3 W	W	D2365	SHEET	1 OF 1
DA	ΤΕ		TITLE		SCALE
9:	5:01:20		WEAR PLATE		2:1
		95:03:06	0.191 WAS 0.197		





6061-T6 (00-A-250/11) 0.063 THICK \$ \$ 00.09.26

ACID ETCH + ALOPINE PER QSI 005 4.1-1) \$
INSTALL FERBLEF (2 PLS) AFFOR ALODINE 7 \$ 00.03.07

MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES